

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010361**Date Inspected:** 26-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhu zhong hai		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SAW welding of weld joint 1G-001 located on PCMK SEG3006AW of 12CW welder is identified as 045265. ZPMC QC is identified as Mr.Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld joint 3G-118 located on PCMK SEG055D of 9DW welder is identified as 050316.ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-TC-U4b-F.

FCAW welding of weld joint 3G-048 located on PCMK SEG055E of 9DW welder is identified as 047866.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-TC—U4b-F.

FCAW welding of weld joint 3F-019 located on PCMK CSD2-PP1045 of CA89 welder is identified as 045240. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4133.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Segment 11DE. The weld designations reviewed are as follows:

SEG072A-031.

BAY#19

FCAW welding of weld joint 1G-044 located on PCMK BP025-011 of BP11 welder is identified as 062731. ZPMC QC is identified as Mr. Zhou Cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-TC-U4b-F.

OUTSIDE SEGMENT

ZPMC Magnetic particle (MT) technician found Transverse cracks in two locations of segment 7BW , the weld number is identified as SSD11-PP51-003/004. But ZPMC not reported regarding these cracks, when this Caltrans Quality Assurance inspector observed this and informed to ABF QA Mr.Wei jiano bo and ZPMC QC Mr.Wang xian pin, then they agreed to raise Critical welding repair report for Caltrans approval.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Patterson,Rodney

QA Reviewer